

# ASA P Pls. Dart Aerospace Ltd.

Date: Tuesday, 11/21/2006 10:52:42 AM  
 User: Chantal Lavoie

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FITTING
Job Number	: 29560		
Estimate Number	: 11396		
P.O. Number	: N/A	Part Number	: D32993
This Issue	: 11/21/2006	Drawing Number	: D3299 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>  </u>	Due Date	: 11/28/2006
Checked & Approved By	: <u>  </u>	Qty:	21
Comment	: Est: A 04.10.04 New issue KJ/JLM      8 Um: Each		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6H1000	6061-T6 1" HexBar
		Comment: Qty.: 0.1925 f(s)/Unit Total : 1.5397 f(s) 6061-T6 1" HexBar Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.00" Hex (M6061T6H1.000) Identify as D3299-3 Batch: <u>1102605</u>
2.0	HAAS1 → COBRA lathe (HAAS CNC VERTICAL MACHINING #1)	
		Comment: Machine as per Folio FA452 and Dwg D3299 Deburr
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	OUTSIDE SERVICE	OUTSIDE SERVICES
		Comment: Sub-Contracting OUTSIDE SERVICES Issue P/O: <u>2544</u> Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required
		<u>Codel11122</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 02/12/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 10:52:42 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 29560

Part Number: D32993

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage  
Ensure Material Release Note is attached

BB 06/12/06 (21)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location: 8421

10/4/12 (21)

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

SD 06/12/12 (21)

Job Completion



U 06/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

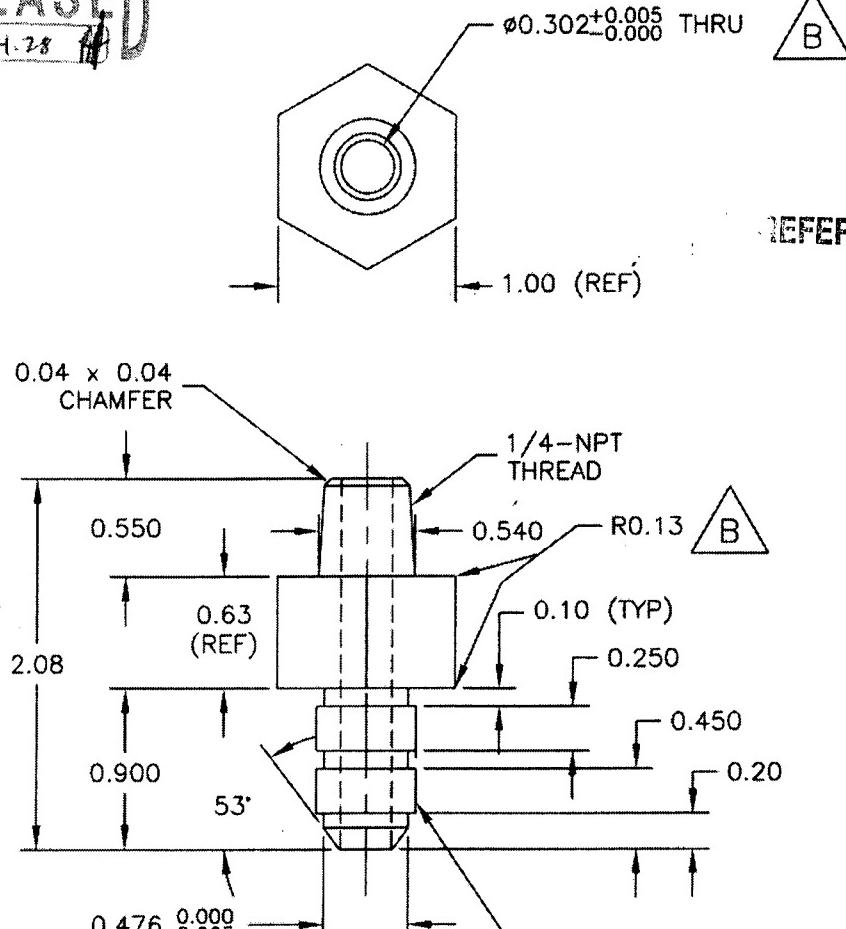
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

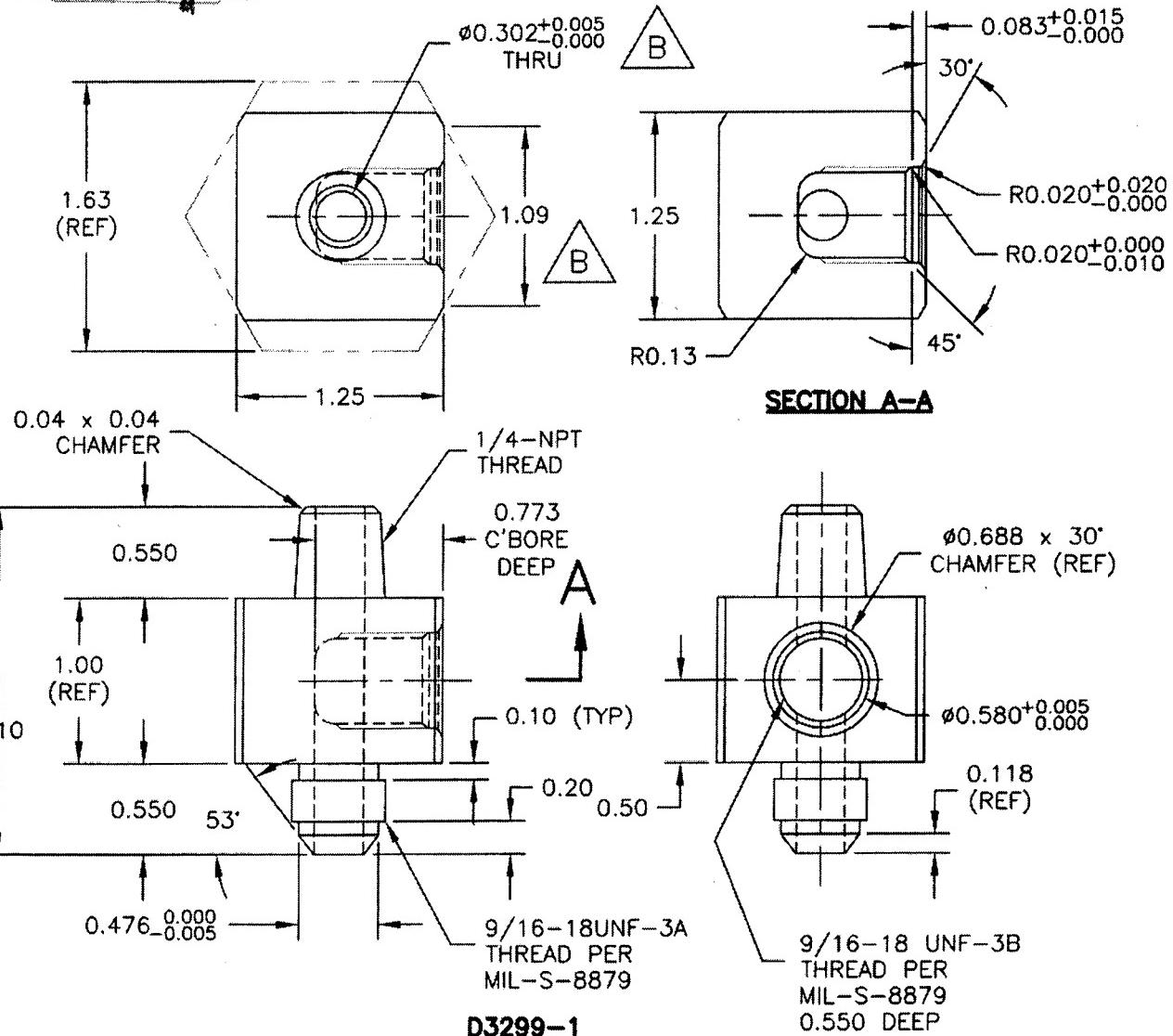
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

**RELEASED**  
05.04.28**D3299-3****D3299-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

**DART**

DESIGN <i>P</i>	DRAWN BY <i>P</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; Ø0.302 WAS Ø0.297	

**RELEASED**  
05.04.28 *H***D3299-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

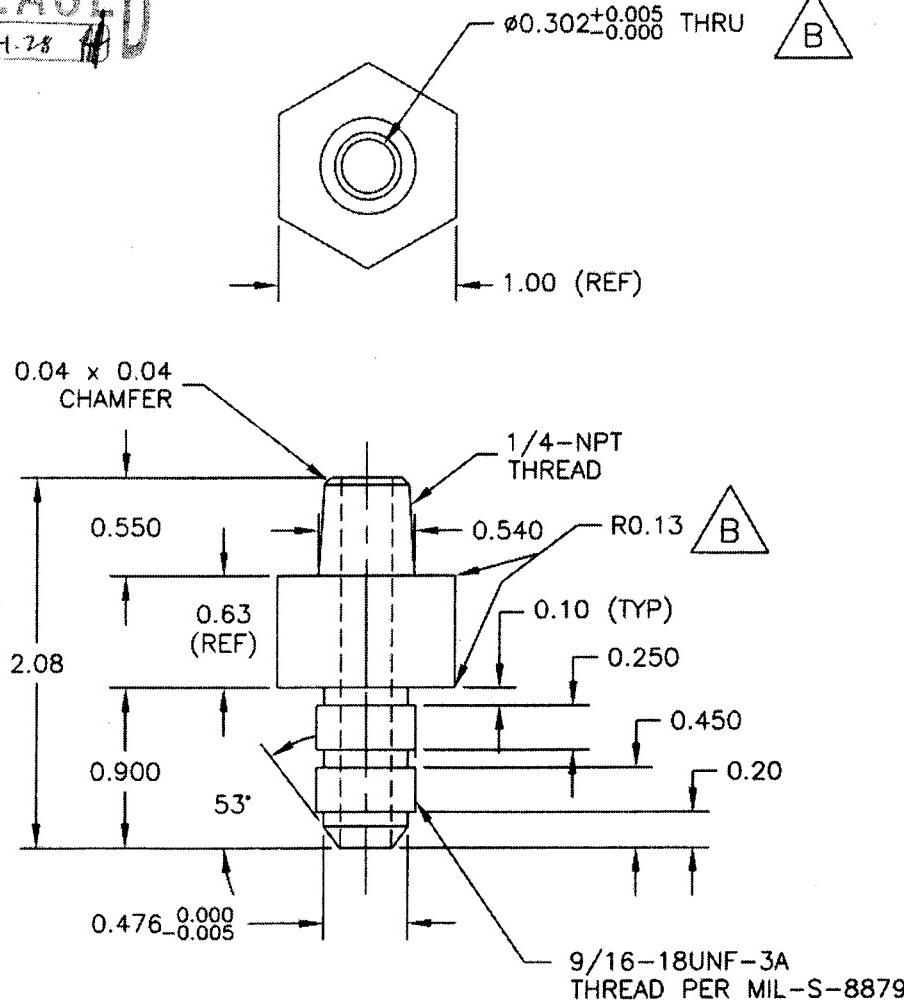
**REFERENCE ONLY**

.574 hors page.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

RELEASED  
05.04.28



D3299-3

D3299-3 NOTES:

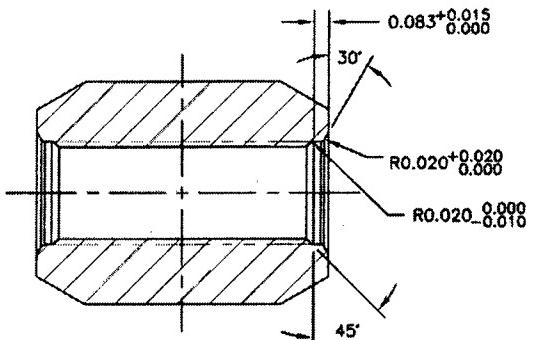
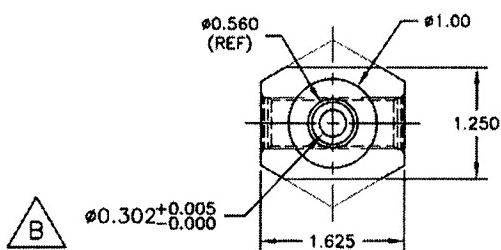
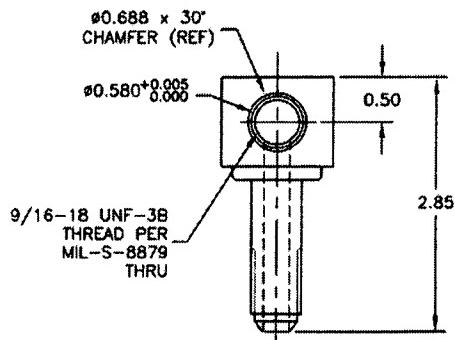
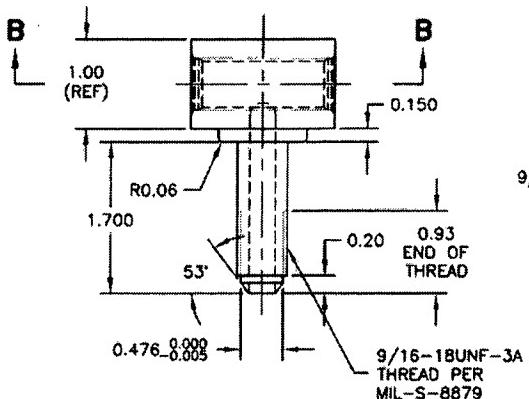
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- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
*PREFERENCE ONLY*  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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**DART**

DESIGN <i>H</i>	DRAWN BY <i>H</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28	TITLE FITTING	SCALE 1:2	

**RELEASED**  
05.04.28**SECTION B-B**  
SCALE 1:1**D3299-5****ENCLOSURE ONLY****D3299-5 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/B OR QQ-A-225/B) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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DART AEROSPACE LTD	Work Order:	29560
Description: Fitting	Part Number:	D3299-3
Inspection Dwg: D3299	Rev: B1	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

# X First Article Prototype

Measured by:	J. F.
Date:	06/11/21

Audited by:	J.L
Date:	06/11/22

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	04.09.17	New Issue	KJ/JLM	
B	05.05.25	-0.005/+0.000 added to 0.476	KJ/JLM	

**REFERENCE ONLY**

TNM

**ANODISATION et PEINTURE TNM INC.**

C. OF C



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2  
Telephone: (514) 429-7777 Fax: (514) 429-5108  
Certifié ISO 9001-2000 / AS9100 certified  
approuvé NADCAP approved

51578

30-Nov-2006

**CLIENT / CUSTOMER:**

DART AEROSPACE LTD.  
1270 ABERDEEN STREET  
HAWKESBURY , ONTARIO  
K6A 1K7

**CERTIFICATE OF COMPLIANCE**  
**CERTIFICAT DE CONFORMITE**

**PURCHASE ORDER/**  
**NO. DE COMMANDE:** 00002544



ITEM #	COMMAND #	QUANTITY	PART NUMBER	DESCRIPTION	WORK PROCESS	REMARKS
1	21	✓	21	D3299-3 ✓	B29560 ✓	AS PER DWG D3299 REV. B BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

1            21            ✓            21            D3299-3            ✓            B29560            ✓  
AS PER DWG D3299 REV. B  
BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL  
OVER

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.  
Travel cards have been filed and are available for viewing upon request.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager